Work Order ID June-25-13 11:50:06 Al			*10	374	<b>6</b> *						Page 1	
Item ID: D4021- Revision ID:	9		Accept	*/	1900	<b>040</b>	100	)* s	setup Star	i Zi	S1*	-
Item Name: Bushing	,			-					Stop	*N	S2*	
Start Date: 7/08/13 Required Date: 7/08/13 Reference:					Cust Item II Customer:	D:	- 1.	T	Run Star	• • •		
Approvals: Proces	ss Plan: MJ	Date: 13-040-75	Tooling:		Da	te:		r		1/1	R1*	
QC:_		Date:	SPC (Y/N):		Da	te:		·	Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	s	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D4021	В											
*100 *100* Hardinge Hardinge CNC Lathe Small	DWG REV FOLIO RE	LINE TO .375" MAX OD *		0AS 40 9-8	13/0	7/01		40	Ø_			
110 *110* QC Quality Control	QC2- Inspect parts off  Memo	machine FAI/FAIB	0.00	040 40	13/6	7/61		40	Ø			

DQA: Date:				·							TRAGE		
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		ork Order up	odate only	AEROSPACE
						DISPOSITION					PARTMENT		
Work Orde	er: _					DIST 05/11014				AGAMS1 DE			
Part N	No					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	No					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Desci	ription of work order update	1	nitial	Acti	ion	Sign &	·	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport													
Unapproved	ــــــــــــــــــــــــــــــــــــــ						EAL	UTCAT	TEGORY				<u> </u>
Landi	ng G						FA	OLI CA	IEGONT		<u> </u>		
Landi		<b>ear</b> Bending Centre No	ot Concer	ntric		General Bend BOM/Route		Folio/P Grain	rogram		Outside Dim Over/Under		Pressure/Forced Set-up
	Н	Cracks				Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	ct	Temperature/Cure
	$\vdash$	Crimp/Kir	ık/Ripple	/Wave		Burrs		1 '	on Incomplete/Un	· —	Part Lost/Mi	· · · · -	Weld
	Н	Cuffs				Contamination		1	ions Incomplete/U	Inclear	Part Moved	<u> </u>	Wrong Stock Pulled
	-	Crushing				Countersink		1 -	ned/off center		Positioned V	_	_
	Н	Heat Trea				Cut Too Short		Mislabe	·		Power Loss/	Surge	Other
	—	Inspection	-	Tube		Drawing		Misread	d				
	$\vdash$	Marks/Ch				Drill Holes		Off-set					
	$\overline{}$	Turning S				Finish	<u> </u>	Out of 0	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Work Order II.  June-25-13 11:50:06		3746			*10	374	46*							Page 2
Item ID: D402 Revision ID: Item Name: Bushin Start Date: 7/08/1 Required Date: 7/08/1 Reference:	ng 13	Start Qty: 40.00 Req'd Qty: 40.00		*40* *40*	Accept	*	V90 Cust Ite Custom		100			Start Stop	*N:	S1* S2*
		n:	Date:		Tooling: SPC (Y/N):			Date:			Run	Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center ID  120 *120* QC Quality Control		Operation Description QC8- Inspect parts - secon	• • •		Set Up/ Run Hours 0.00		Tool I		Plan Code	Accept Qty	Qty		Reject Number	Insp. Stamp  OAS  08
130 *130* Packaging Packaging		Identify as per dwg & Stoo	ck Location	w A	0.00					40				13-07-0
*140 *140* QC Quality Control		QC21- Final Inspection - \ Memo	Work Order	Release	0.00	ı						[? 	3/7/ mi	49

13-7-03

DQA:		Date	:										V	
QA Closed:		Date	•		WORK ORDER NON	-C(	ONFO	RMANCE / UF		Wo	ork Order up	odate only	$\neg$	AEROSPACE
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	•	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality Quality
NCR No.				Use-as-is Suspected Unapproved		Thermoforming Finishing  Large Fab Composite				Rec/Sto	re/Packaging Supplier		Other	
Root				Desc	ription of work order update	Π	Initial	Acti	ion		Sign &		T	
Cause	Dat	te Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption		Date	Verification	1	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
onoppiotes [				L		FAI	ULT CA	TEGORY				<u> </u>		
Landir	ng Gear				General						- "			
	Crack Crimp Cuffs Crush Heat	e Not Conce s p/Kink/Rippl	e/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Grain Hardwa Inspect Instruct	ion Incomplete/Un tions Incomplete/U gned/off center eled	•		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Femperature/Cure Weld Wrong Stock Pulled Other
		s/Chatter			Drill Holes	L	Off-set							
		ng Sequence			Finish	L	4	Calibration						
	I IWave	/Twist in Tu	ihe	- 1	Fit/Function	1	I Out of	Saguanca						

Page 1

Work Order ID:

103746

Parent Item:

D4021-9

Parent Item Name:

Bushing

**Start Date: 7/08/13** 

Required Date: 7/08/13

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP Rev:B as per dwg REV.A

IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	·	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 304 ROUND BAR 0.375		Purchased	No	2 Ts		f	1.3640		3.32	PAS 40	13/	07/01
1 : E :		4	Location		Loc Oty	<u>Lo</u>	c Code			9-80		
•	*		MAT029	<del></del> .	1.364							
	`. ·			125585	1.364				<del></del>			
			To the state of th	176152				9	3 4			

DQA:			Date:						_				TQAG <sup>L</sup>
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Vork Order up	ndate only	AEROSPACE
QA Closeu.			Date.								<del></del>	<u> </u>	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
	_					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	۱o.					Scrap		ļ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۱o		<del>.</del>			Suspected Unapproved			Large Fab	Composite _		Supplier	],
Root		÷			Desc	ription of work order update		nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design		•				•							
Doc/Data													
Equip/Tooling	Ц		ļ										
Handling/Pre													
Material	Щ												
Operator	Ш						1						
Offset/Setup	Н												
Process	$\vdash\vdash$										·		
Supplier	$\vdash \vdash$												
Training	$\vdash\vdash$												
Transport Unapproved	H				į		İ						
опаррточео	<u> </u>		l			· <del>-</del> · <del>-</del>	FΔI	LIST CΔ	TEGORY			t	
Landi	ng G	iear				General		<u> </u>					
		Bending				Bend		] Folio/F	rogram	Γ	Outside Dim	ensions	Pressure/Forced
	$\vdash$	Centre No	ot Concer	ntric		BOM/Route		Grain		F	Over/Under	<u> </u>	Set-up
	П	Cracks				Broken/Damage/Defect		Hardwa	ire	<u> </u>	Part Incorre	<del> </del>	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		]Misalig	ned/off center		Positioned V	<u></u>	_
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	'Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	t				
		Marks/Cl	natter			Drill Holes		Off-set					
	Ш	Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	be		Fit/Function		Out of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	103-746
Description: Bushing	Part Number:	D4021-9
Inspection Dwg: D4021 Rev: B		Page 1 of 1

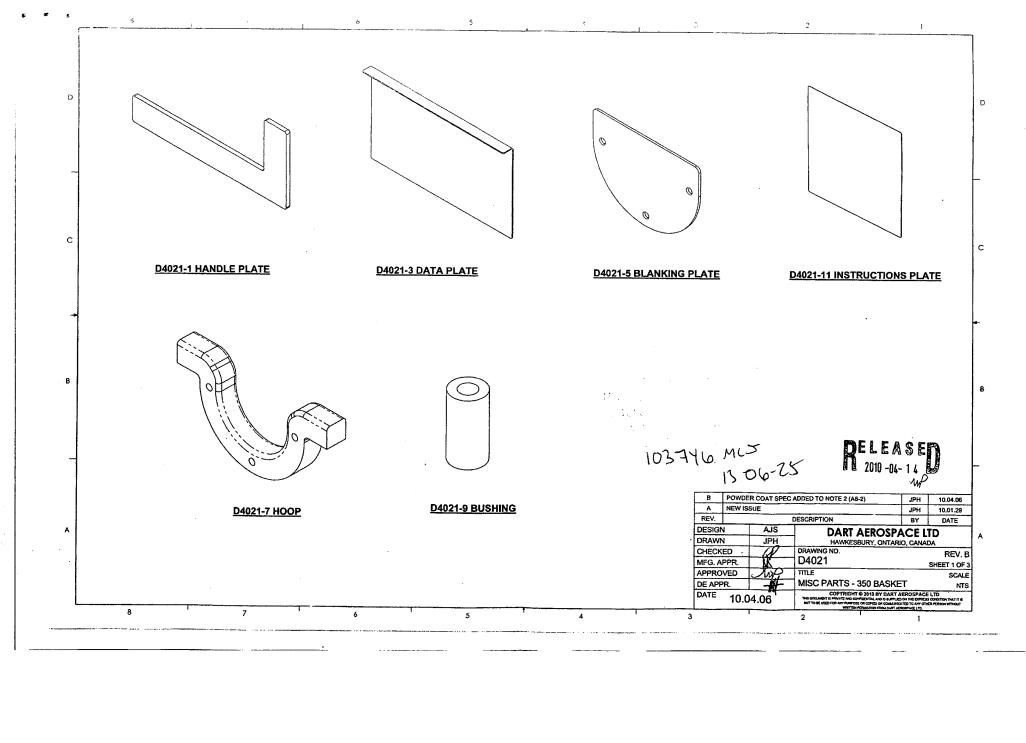
## FIRST ARTICLE INSPECTION CHECKLIST

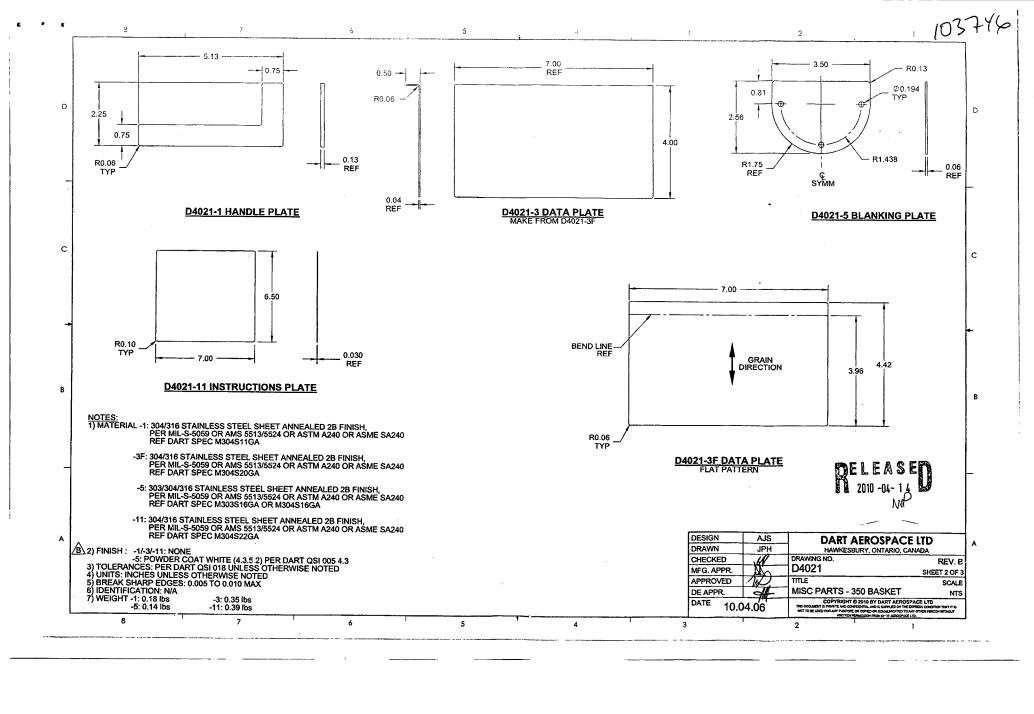
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.00	1 .193			VERN	PHO-12
0.38	+/-0.030	. 370			, .	١,
0.75	+/-0.030	. 753			``	i e
					,	
						WW. 1
						· · · · · · · · · · · · · · · · · · ·
					·	
	, OAS		<u> </u>		<u> </u>	
sured by:	₹ <b>.40</b> 9-89	Audited by:	۹.۲	70AS 98 98	Preliminary A	pproval:

7.40		
Measured by: 9-89	Audited by: J.A	Preliminary Approval:
Date: 13/07/0/	Date: 13 07 02 9-85	Date:

Rev	Date	Change	Revised by	4	Approved
A	10.06.08	New Issue	KJ (	KX	M
				77	

		*
<b>P</b>		· ·
		1
	· · · · · · · · · · · · · · · · · · ·	
		i de la companya de
	· · · · · · · · · · · · · · · · · · ·	
	· · · · · · · · · · · · · · · · · · ·	
	1.7 (4.4 )	
		。 - 統
21,	· · · · · · · · · · · · · · · · · · ·	
		1 7 6
<b>2</b> -1		
<b>*</b> 3		
N. C.	· The Control of th	
•		1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -
		i de la companya de
Kalifornia .	1 1 mil (de la la 18 18 18 18 18 18 18 18 18 18 18 18 18	4 4 4 4





103746

5.00 -R0.50 4 PL R0.10 2 PL 0.63+0.00 0.813 R1.125 REF 2.56 REF Ø0.194 TYP R1.438 — R1.75 ---0.63<sup>+0.00</sup> 2.500

Ø0.191 — -- Ø0.38

0.75

**D4021-9 BUSHING** 

MP

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	JPH	HAWKESBURY, ONTARIO, CA					
CHECKED	10	DRAWING NO.	REV. B				
MFG. APPR.	$\perp N $	7D4021	SHEET 3 OF 3				
APPROVED	1mP	TITLE	SCALE				
DE APPR.	4	MISC PARTS - 350 BASKET	NTS				
DATE 10.0	04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS GOLLAND IS REVIYED AND CONFIDENCE AND IS SUPPLIED ON THE COPYRIST CONFIDENCE WITH IT IS NOT TO BE USED PRIMARY PURPOSE ON COPYED OR COMMANDED TO NOW OTHER POPISION WITHOUT WITH PROPESSION PROPERSION PROPERTY PURPOSE ON THE PROPESSION PROPERTY PROPESSION					

NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
2) FINISH: NONE
3) TOLEPANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 lbs
-8: 0.02 lbs

B

**D4021-7 HOOP** 

4